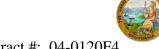
#### **DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 70.28

## WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-002338 Address: 333 Burma Road **Date Inspected:** 17-Mar-2008

City: Oakland, CA 94607

**OSM Arrival Time:** 830 **Project Name:** SAS Superstructure **OSM Departure Time:** 1930 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Japan Steel Works **Location:** Muroran, Japan

**CWI Name:** Chung Kuan and MaKhmud AshadWI Present: Yes No

**Inspected CWI report:** Yes **Rod Oven in Use:** Yes No N/A No N/A Yes N/A **Electrode to specification:** No Weld Procedures Followed: Yes No N/A Yes N/A **Qualified Welders:** No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:** 

34-0006 **Bridge No: Component:** PQR test plate

#### **Summary of Items Observed:**

Witness welding test for PQR #SJ-2942-WP5 (test plate SW-4-1): Caltrans Quality Assurance Inspector (QAI) representative Mr. Danny Reyes and Mr. Wai Pau, travel to Japan Steel Works (JSW) Muroran plant to witness an AWS D1.5 standard PQR qualification welding test. The number of PQR qualification welding test is SJ-2942-WP-5 (test plate SW-4-1). The PQR qualification tests utilizing two welding processes, the Shielded Metal Arc Welding (SMAW) from root pass to the 30mm thick weld metal and Flux Cored Arc Welding (FCAW) from 30mm SMAW weld metal to the top of the test plate were conducted by welder Mr. Kouzou Kobayashi (08-5023) performed in the flat position (1G). The material used for the PQR qualification test specimens was reported by JSW Welding Engnieer Mr. Takaaki Maruya as ASTM a 709M-HPS-485WT plate and having a wall thickness measurement of 110mm. The weld joint design used butt joint, single-V-groove weld with 20mm x 75mm backing bar. The proper filler metal and shield gas used in the test for FCAW is TM-95K2, 1.6 diameter with 100% C02 made by Hobart Brothers, USA. The welder performed the FCAW welding process and parameters have been monitored and recorded by CWI inspectors Mr. Chung Kuan, Mr. MaKhmud Ashadi and JSW Welding Engnieer Mr. Takaaki Maruya, also observed by Caltrans QAI. The welding of this PQR was completed on this date. The preheat temperature of the test plate is to be held at 120 C overnight for the continuation of the welding at tomorrow. Based on Caltrans QA observation, no discrepancies were noted

### **Summary of Conversations:**

As Note within the report above.

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Venkatesh Iyer (858)697-6363, who represents the Office of Structural Materials

# WELDING INSPECTION REPORT

(Continued Page 2 of 2)

for your project.

**Inspected By:** Pau,Wai Quality Assurance Inspector

**Reviewed By:** Brasel,Ron QA Reviewer